

Work Order ID 72361

Friday, July 22, 2011 2:53:27 PM



Page 1

Item ID: D3270-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Scupper Assembly

Start Date: 7/22/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 11-07-22 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3270

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Cut D3270-3 as per Dwg D3270

11-12-23 (X10)

110

Weld per dwg A/R Aluminum rod Batch: A114514 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld D3270-3 to D3270-1 as per Dwg D3270 using welding Jig D3270-041T1 and QSI 004.

11-12-23 (X10)

P10 →

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.12.28 (X10)

W/O: 72361		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3370 241 PAR #: _____ Fault Category: Large FAI NCR: (Yes) No DQA: OK Date: 12/1/11
12-1106 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/1/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/28	#110	Qty +3 Parts Scrap. while Deburring hole operator saw too much mat. of end of tube. R.L. Process.	S 11/12/28 as 7042	Scrap + Destroy No Replu (extra, day)	LL 11-12-28	S 11/12/28	S 11/12/28 as 7042	S 11/12/28
			12/01/11 QSI 47				12/01/11 QSI 47	

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8-12/28



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

M-1/18 12-01-02

7

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START Time:

OVEN TEMPERATURE:

FINISH TIME:

8-30

32001=

9:00

7X M-1 12/04/10

M119480

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Friday, July 22, 2011 2:53:27 PM

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Setup Start



Revision ID:

Stop



Item Name: Fuel Scupper Assembly

Start Date: 7/22/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

7x 0 12/10/10
COUNT

165 Identify as per dwg & Stock Location: 35 0.00



Packaging Memo

0.00

Packaging

12/1/10

170 QC21- Final Inspection - Work Order Release 0.00



QC Memo

0.00

Quality Control

12/1/10

MF
12-01-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 2:53:33 PM

Page 1

Work Order ID: 72361



Parent Item: D3270-041



Parent Item Name: Fuel Scupper Assembly

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3270-1		Manufactured	No			100	Each	53.0000	1	6			
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Mounting Base

Location

Loc Qty

Loc Code

WA021

53

24076

53

M6061T6T0.375W.035

Purchased

No

100

f

224.5100

0.6666

4.210105



6061-T6 RD Tube .375 x.035W

Location

Loc Qty

Loc Code

MAT014

224.51

104913

31.75

112652

192.76

EL 11-12-22

10

EL 11-12-22

6.66

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

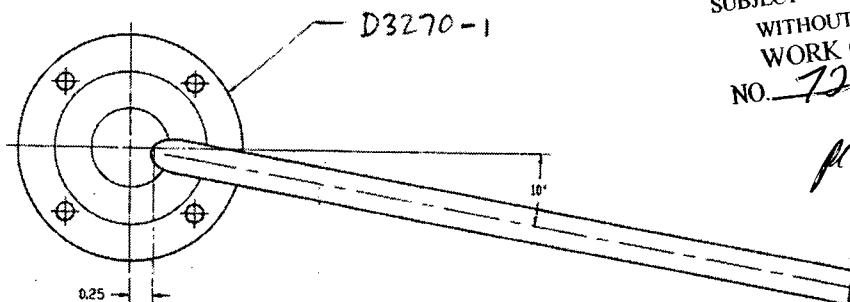
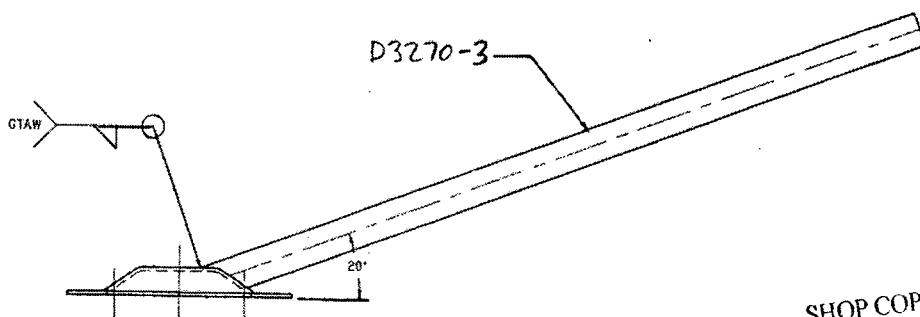
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NOTE: Date & initial all entries



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D3270	SHEET 1 OF 2
DATE	05.07.14			TITLE	SCALE
				FUEL SCUPPER DRAIN ASSEMBLY	NTS
A	04.02.20			NEW ISSUE	
B	05.07.14			ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23 *[Signature]*



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72361

11-07-22

D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

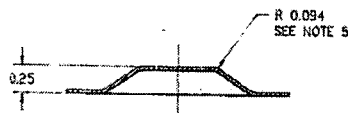
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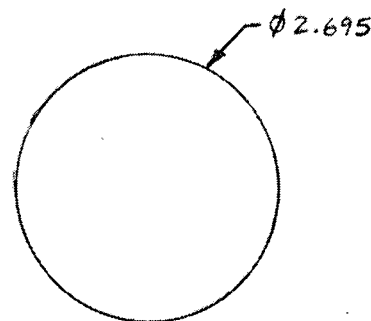
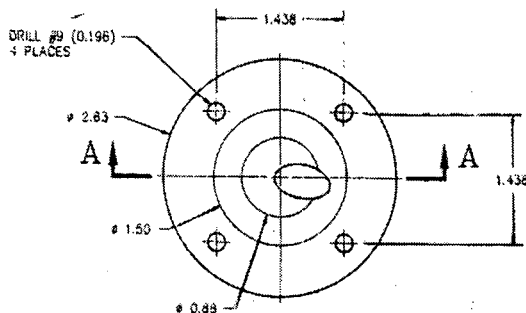


DESIGN	<i>HH</i>	DRAWN BY	<i>HH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CP</i>	APPROVED	<i>HH</i>	DRAWING NO. D3270 REV. B SHEET 2 OF 2
DATE	05.07.14	TITLE	FUEL SCUPPER ASSEMBLY	SCALE NTS
A	04.02.20	NEW ISSUE		
B	04.02.20 05.07.14	ADD D3270-1 FLAT PATTERN		

RELEASED
04.02.23 *HH*



SECTION A-A

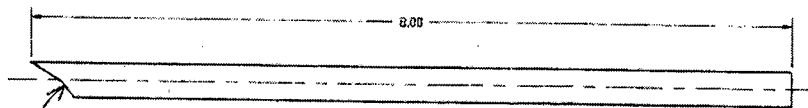


D3270-1 FLAT PATTERN

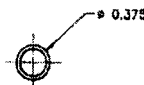


D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT
D3270-1



D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061T6T.0375W.035)

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